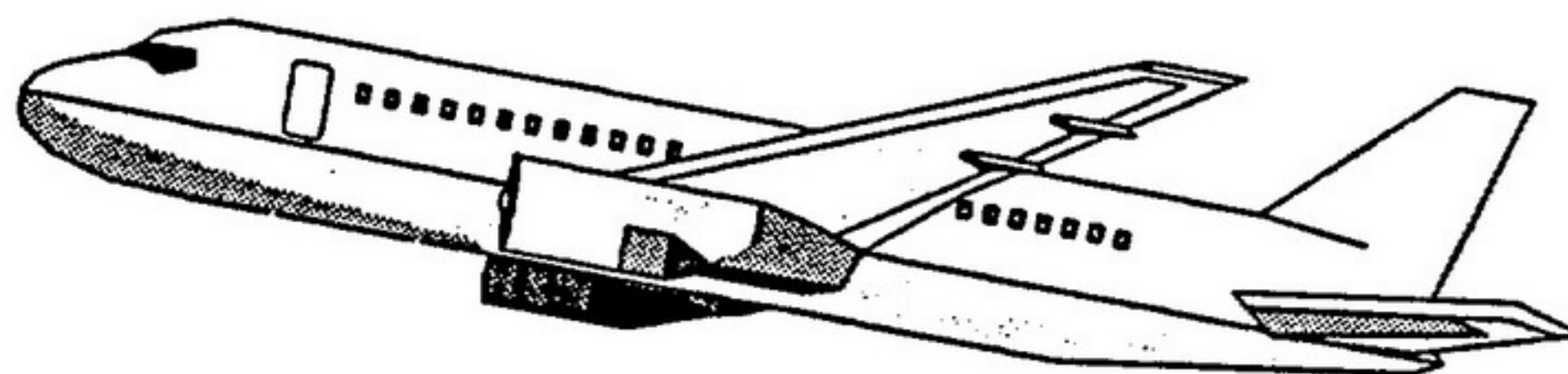


TO: HOLDERS OF 10260 SERIES OXYGEN REGULATOR ASSEMBLY
COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

REVISION NO. 5 DATED September 9, 1997

HIGHLIGHTS

Chapter/Section and Page No.	Description of Change	Effectivity
All Pages	Updated Scott logo and CMM formatting.	N/A
Intro-1-2	Updated part numbers to new part number format. Added Scott Aviation address for product support.	All Models
1	Changed wrong part number in para. 2.	All Models
101-107	Reorganized testing section for clarification. Included specific test equipment/ materials in Tables 101 and 102 with equivalent substitutes statement. Changed Figure 101 and added Figures 102 and 103 with new procedures. Added note that was missing from Table 103. Added relief valve to Table 104. Corrected item number in Table 104.	All Models
301	Added equivalent substitutes statement to Table 301. Corrected item number in Table 301	All Models
402	Degreasing Agent (Table 401) changed to Genesolv 2000. Added vendor information to table.	All Models
501	Added diaphragm to 1. NOTE: Added para. C.	All Models
601	Added diaphragms to para. E.	All Models
701	Added new warnings.	All Models
702	Added equivalent tools or equipment statement to para. 2. and removed it from Table 701. Added equivalent materials statement to para. 3. Added ven- dor information to Table 702.	All Models
704	Modified procedural steps in 5. Changed torque value of items 100 & 110 in step 5.N.	
801/802	Changed torque values of IPL items 100 and 110.	All Models
901	Added Table 902 (Test Equipment).	All Models
1001, 1002	Added vendor, deleted vendors. Added note to Table 1001.	All Models
1003	Added blank page.	All Models
1004	Changed Figure 1 to show new single piece bezel-lens (40A, 80A).	All Models
1005, 1006	Updated part numbers to new format. Added new single piece bezel-lens to IPL (40A, 80A).	All Models



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

FOR:

10260 SERIES OXYGEN REGULATOR ASSEMBLY

RECORD OF REVISIONS

Retain this record in the front of the manual. On receipt of revisions, insert revised pages in the manual and enter revision number, date inserted, and initials.

[illegible][illegible]

RECORD OF TEMPORARY REVISIONS

Keep this record in the front of this manual. When a temporary revision to this Component Maintenance Manual (CMM) is received, put the revision pages into this CMM and write in the revision number, revision date, date filed and your initials into the table below.

[illegible][illegible]

SERVICE BULLETIN LIST

Keep this record in the front of this Component Maintenance Manual (CMM). When you receive service bulletins for this CMM, put the service bulletin pages into this CMM and write the date issued and the date incorporated in the table below.

[illegible][illegible]

LIST OF EFFECTIVE PAGES

<u>Subject</u>	<u>Page</u>	<u>Date</u>	<u>Subject</u>	<u>Page</u>	<u>Date</u>
Title Page	T-1/2	Sep 9/97	Check	501/502	Sep 9/97
Record of Revisions	RR-1/2	Sep 9/97	Repair	601/602	Sep 9/97
Record of Temporary Revisions	RTR-1/2	Sep 9/97	Assembly	701 702 703 704 705/706	Sep 9/97 Sep 9/97 Sep 9/97 Sep 9/97 Sep 9/97
Service Bulletin List	SBL-1/2	Sep 9/97			
List of Effective Pages	LEP-1/2	Sep 9/97	Fits & Clearances	801/802	Sep 9/97
Table of Contents	TC-1/2	Sep 9/97	Special Tools, Fixtures and Test Equipment	901 902 903/904	Sep 9/97 Sep 9/97 Sep 9/97
Introduction	INTRO-1 INTRO-2	Sep 9/97 Sep 9/97			
Description & Operation	1 2 3/4	Sep 9/97 Sep 9/97 Sep 9/97	Illustrated Parts List	1001 1002 1003 1004 1005 1006	Sep 9/97 Sep 9/97 Sep 9/97 Sep 9/97 Sep 9/97 Sep 9/97
Testing & Fault Isolation	101 102 103 104 105 106 107/108	Sep 9/97 Sep 9/97 Sep 9/97 Sep 9/97 Sep 9/97 Sep 9/97 Sep 9/97			
Disassembly	301 302 303/304	Sep 9/97 Sep 9/97 Sep 9/97			
Cleaning	401 402	Sep 9/97 Sep 9/97			

TABLE OF CONTENTS

<u>SUBJECT</u>	<u>PAGE</u>
Introduction	INTRO-1
Description and Operation	1
Testing and Fault Isolation	101
Automatic Test Requirements	N/A
Disassembly	301
Cleaning	401
Check	501
Repair	601
Assembly	701
Fits and Clearances	801
Special Tools, Fixtures and Test Equipment	901
Illustrated Parts List	1001

INTRODUCTION

1. Scope

This manual establishes the user maintenance, overhaul and service procedures for servicing the 10260 Series Oxygen Regulator Assemblies described herein. Dash configurations of the 10260 Series Oxygen Regulator Assemblies that are covered by this CMM are indicated below:

10260-02*
10260-04*
10260-06
10260-08
10260-18

* Items with single digit dash numbers (e.g., 10260-2, 10260-4) are identical to items with two digit dash numbers (e.g., 10260-02, 10260-04, respectively).

This manual provides the following information:

- A. Specifies proper safety regulations to be followed while performing service on oxygen equipment used in aviation applications.
- B. Establishes the proper sequence of operations to be performed on the defined equipment.
- C. Provides the user with data necessary to properly maintain, check, test and repair the equipment.

2. WARNINGS

The following WARNINGS are presented to inform the user of this manual of the requirements which shall be adhered to when performing service procedures on this equipment. Additional WARNINGS will be found in the procedural steps in the manual.

WARNING: ANY SERVICE OR OVERHAUL PERFORMED ON THIS APPARATUS SHALL BE DONE ONLY BY THOSE FACILITIES EXPERIENCED IN, OR BY PERSONNEL KNOWLEDGEABLE OF, AVIATION OXYGEN EQUIPMENT. IF NONE IS KNOWN, CONTACT SCOTT AVIATION OR ITS DISTRIBUTORS FOR NAMES OF AUTHORIZED SERVICE CENTERS.

ALL PROCEDURES DESCRIBED IN THIS MANUAL SHALL BE PERFORMED IN AN AREA FREE OF OIL, GREASE, FLAMMABLE SOLVENTS OR OTHER COMBUSTIBLE MATERIALS. DUST, LINT, AND FINE METAL FILINGS, ARE ALSO POTENTIAL COMBUSTIBLES THAT MIGHT IGNITE, AND RESULT IN AN EXPLOSION, WHEN EXPOSED TO PRESSURIZED OXYGEN.

2. WARNINGS (Continued)

WARNING: DO NOT ALLOW OIL, GREASE, FLAMMABLE SOLVENTS, OR OTHER COMBUSTIBLE MATERIALS TO COME IN CONTACT WITH PARTS THAT WILL BE EXPOSED TO PRESSURIZED OXYGEN. DUST, LINT, AND FINE METAL FILINGS, ARE ALSO POTENTIAL COMBUSTIBLES THAT MIGHT IGNITE, AND RESULT IN AN EXPLOSION, WHEN EXPOSED TO PRESSURIZED OXYGEN.

3. Product Support Services

Product support services for the equipment covered by this document are provided by Scott Aviation. These services include repair and overhaul, replacement parts, and technical documentation.

Scott Aviation (Vendor Code 53655)
A Figgie International Company
225 Erie Street
Lancaster, New York 14086-9502
U.S.A

Telephone: 716-683-5100
FAX: 716-681-1089

DESCRIPTION AND OPERATION

1. General

This manual provides overhaul instructions with illustrated parts list for the 10260 Series Oxygen Regulator Assemblies (see Figure 1).

All regulators within the 10260 Series are similar in internal construction. The dash configurations of the 10260 Series Oxygen Regulator Assemblies differ only in external hardware such as gauges, adapters, nipples and connectors. Refer to the Illustrated Parts List section of this CMM for external regulator differences. In addition to external differences, the 10260-06 and 10260-08 also use different outlet pressure settings than the other dash configurations.

2. Purpose of Equipment

The 10260 Regulator is a pressure reducing mechanism that reduces a 2000 psig, or lower, variable oxygen source to a pre-set constant-gauge-pressure at approximately 75 psig (94 psig for 10260-06 and 10260-08).

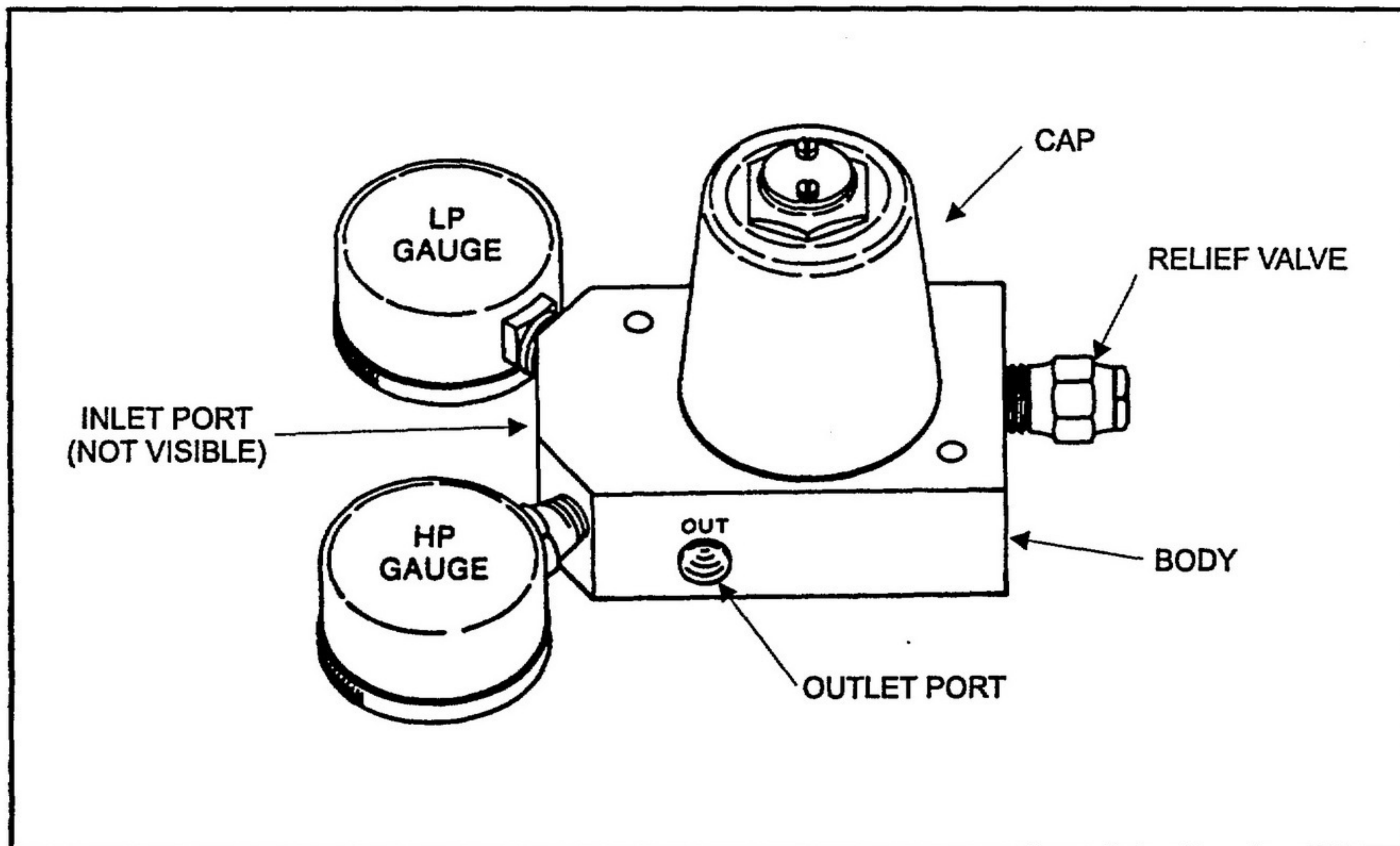


Figure 1: Oxygen Regulator Assembly

3. Typical Installation

A typical installation of the 10260 Series Oxygen Regulator in a pressurized control cabin is shown in Figure 2. In this application, an oxygen source consisting of high pressure oxygen cylinders (1) is connected to the inlet port of regulator (2) through check valve (3). The oxygen supply pressure is reduced by the 10260 Series Regulator. The reduced pressure is routed to the inlet port of diluter demand regulators (4) when valve (5) is open. Supply pressure to the diluter demand regulators is maintained at a pre-determined level by the 10260 Series Oxygen Regulator Assembly.

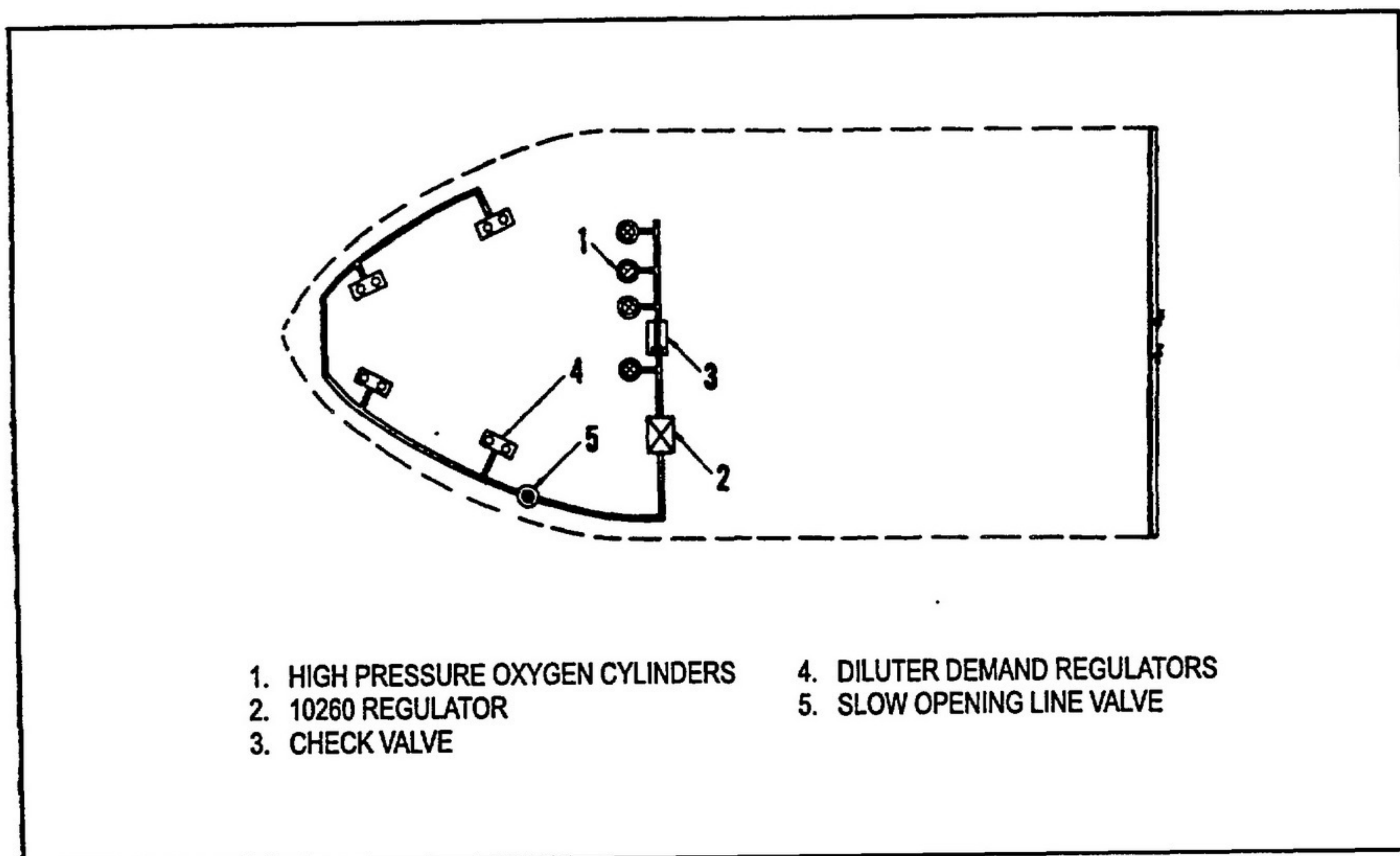


Figure 2: Typical Installation

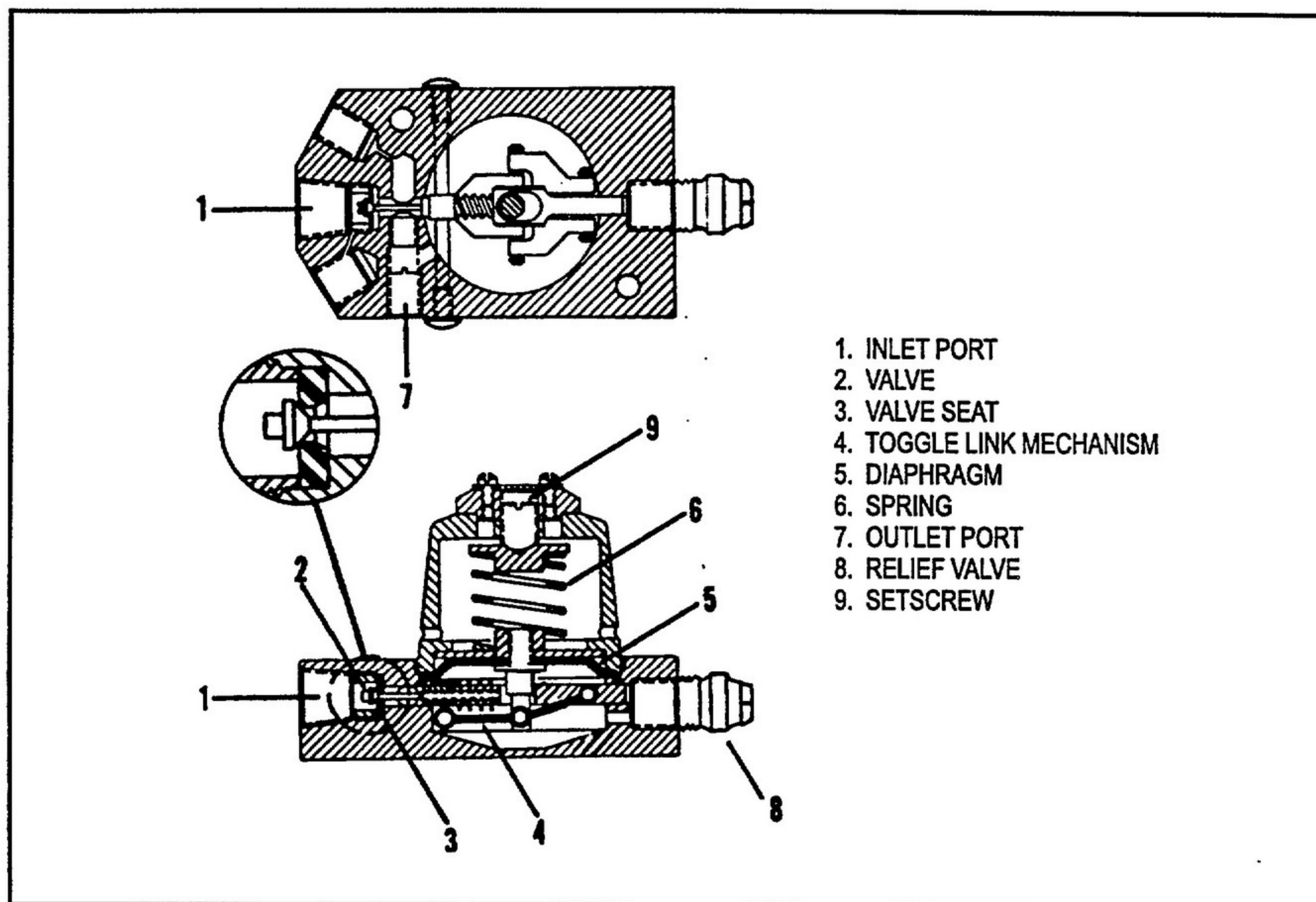


Figure 3: Regulator Cross Section

4. Operation (See Figure 3)

High-pressure oxygen enters the regulator through inlet port (1). Oxygen flow into the regulator is controlled by valve (2). Valve (2) is held against seat (3) by toggle link mechanism (4) which is maintained in the closed position by outlet pressure acting on diaphragm (5). Spring (6) force is preset by adjustment of the setscrew (9) and acts on the upper surface of the diaphragm. If spring force exceeds the force created by the outlet pressure acting on the diaphragm (5), the toggle link joint moves downward thus moving valve (2) away from its seat. This allows oxygen to flow. Flow through outlet (7) continues until outlet pressure increases sufficiently to counter-balance the spring force to close the valve. Relief valve (8) is preset to relieve at outlet pressures in excess of 100 to 110 psig, and to re-seat at reduced pressures.

TESTING AND FAULT ISOLATION

1. General

This section contains the testing and fault isolation procedures used to evaluate performance of the 10260 Series Oxygen Regulator Assemblies. Should a failure occur during testing procedures, refer to the troubleshooting chart (Table 104) for fault isolation and suggestions to remedy the problem. Refer to the ILLUSTRATED PARTS LIST section of this manual for the item numbers given in parentheses.

2. Test Equipment

Test equipment required for testing of the 10260 Series Oxygen Regulator Assemblies is given in Table 101. Equivalent test equipment may be used for the listed items.

Table 101: Test Equipment

NOMENCLATURE	PART NUMBER	MANUFACTURER (with Vendor Code)
Flexible Hose (½ inch [1.27 cm] ID, 1-1/8 inch [2.86 cm] OD, TYGON® Tubing)	AAC00038	Norton Company Worcester MA 01615-0008 USA (V44197)
Valve, Flow Control	B18VF8	Whitey Co. Highland Heights, OH 44143-1533 USA (V12623)
Flowmeter (0.62 - 6.2 slpm) (38.1 - 381 slpm)	1110CC71DBGAA 1110CK42CBGAA	Emerson Electric Co. Brooks Instrument Div. Hatfield, PA 19440-3052 USA (V91556)
Gauge, Input Pressure (0-2000 psi)	1403 Series	Ametek U.S. Gauge Div. Sellersville, PA 18960-2625 USA (V61349)
Gauge, Output Pressure (0-200 psi)	1403 Series	
Input Plug (brass, ¼ inch ANPT pipe plug)	-----	Commercially Available
Regulator, Test (15 - 2500 psig)	26-1014-26	Tescom Corp. Elk River, MN 55330-2445 USA (V5H642)
Piezometer	10260-T58-1	Scott Aviation Lancaster, NY 14086-9502 USA (V53655)
*TYGON is a registered trademark of the Norton Company, Worcester, MA.		

3. Test Materials

A list of consumable test materials is presented in Table 102. Equivalent materials may be used for the listed items.

Table 102: Consumable Test Materials

MATERIAL	DESCRIPTION	MANUFACTURER (with VENDOR CODE)
Leak Test Solution	Sherlock Leak Detector Solution (MIL-L-25567)	Winton Products Co. Inc. Charlotte, NC 28236 USA (V23316)
Test Gas	Oxygen (MIL-O-27210, Type 1) (refer to Note 1)	Local Vendor
<p>Note 1: Oxygen (MIL-O-27210, Type 1) is the test gas specified in the test procedures in this section of the manual. If Nitrogen or Air (specified in Note 2) is used for the test gas, the applicable test parameters must have the appropriate density correction factors calculated and used, and the test equipment must be calibrated for the test gas.</p> <p>Note 2: Nitrogen (MIL-P-27401, Type 1). Air, oxygen quality conforming to the following:</p> <ul style="list-style-type: none">- 3 parts per million maximum total hydrocarbons by weight.- No particles greater than 100 microns.- Maximum of 0.02 milligram of water vapor per liter of gas at 70 °F (21 °C) and 760 mm Hg (Equivalent dew point -68 °F at 760 mm Hg).		

4. Test Sequence

Unless otherwise specified, tests of the 10260 Series Oxygen Regulator Assemblies (also referred to as regulator assembly) shall be performed in the order in which they are presented within this document.

5. Test Procedures

The test procedures described in this section require the 10260 Series Oxygen Regulator Assembly to be connected to test equipment as shown in Figures 101 thru 103.

It is necessary to remove the name plate (130) and the screws (150) for adjustment of the output pressure of the regulator assembly.

CAUTION: OXYGEN CONFORMING TO FEDERAL SPEC. MIL-O-27210, TYPE 1, IS USED AS THE TEST GAS WHEN PERFORMING THE TESTS OUTLINED IN THIS SECTION. IF NITROGEN OR WATER PUMPED AIR IS USED, APPROPRIATE DENSITY CORRECTION FACTORS SHALL BE APPLIED TO THE FLOW METER USED, TO CORRECT NOT ONLY THE EFFECT ON THE METER ITSELF, BUT ALSO THE EFFECT ON THE PERFORMANCE OF THE REGULATOR ASSEMBLY WITH THE LOWER DENSITY GAS. ALL FLOWS ARE NOTED IN LPM (NTPD).

5. Test Procedures (Continued)

A. External Leak Test

NOTE: Be certain low pressure relief valve (100, 110, IPL Fig. 1) is installed in the regulator assembly.

- (1) Attach regulator assembly to the test equipment as shown in Figure 101 and set flow control valve to the closed position (clockwise).
- (2) Adjust test regulator to 1800 psig (12.41 MPa) as shown on input pressure gauge.
- (3) Look at the oxygen gauge (60) and make sure that the pressure on the gauge is approximately the same as the pressure on the input pressure gauge attached to the test regulator.
- (4) Apply leak test solution (refer to Table 102) to the external connections of regulator assembly. There shall be no leaks for a period of two minutes.
- (5) Decrease test regulator pressure to 0 psig (0 MPa) as shown on the input pressure gauge, and relieve the pressure in test setup by slowly adjusting flow control valve to the open position.

B. Internal Leak Test

- (1) Attach regulator assembly to test equipment as shown in Figure 101 and set flow control valve to the closed position.
- (2) Adjust test regulator to 150 psig (1.03 MPa) as shown on input pressure gauge.
- (3) Slowly turn the flow control valve 1/4 turn open (counterclockwise) then slowly return it to the closed position (clockwise) to permit a stable output pressure on output pressure gauge. Repeat if necessary.
- (4) Test the leakage past the regulator valve seat in the regulator assembly for a period of ten minutes. Leakage is shown by an increase of pressure on output pressure gauge, greater than 75 psig / 0.52 MPa (94 psig / 0.65 MPa for 10260-06 and 10260-08). There shall be no leakage.
- (5) Adjust the test regulator to 1800 psig (12.41 MPa) as shown on input pressure gauge.
- (6) Repeat steps (3) and (4).
- (7) Decrease test regulator pressure to 0 psig (0 MPa) as shown on the input pressure gauge, and relieve the pressure in test setup by slowly adjusting flow control valve to the open position.

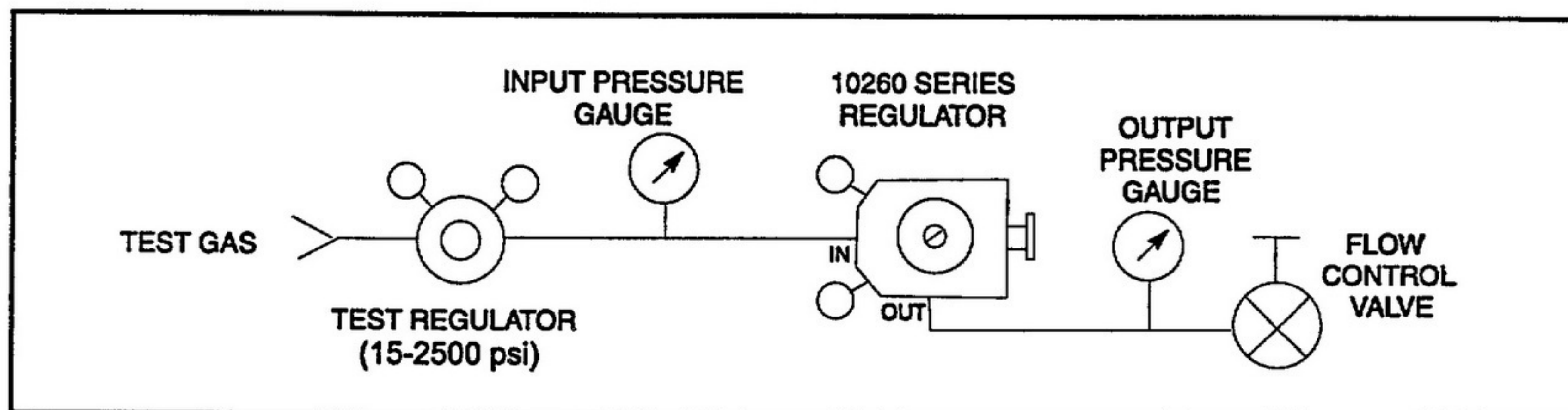


Figure 101: Test Set-up

5. Test Procedures (Continued)

C. Relief Valve Test

NOTE: Relief valve (100 or 110, IPL Figure 1) may be tested separately prior to installation in the unit.

- (1) Attach regulator assembly to the test equipment as shown in Figure 102.
- (2) Attach flowmeter, piezometer, flexible hose, and output pressure gauge to relief valve on regulator.
- (3) Adjust test regulator to have a flow indication of 200 lpm (NTPD) on flowmeter.
- (4) Input pressure gauge must be less than 140 psig / 0.97 MPa (160 psig / 1.10 MPa for 10260-06 and 10260-08) for a flow rate of 200 lpm.
- (5) Adjust test regulator to lower the input pressure to 90 psig / 0.63 MPa (110 psig / 0.76 MPa for 10260-06 and 10260-08) as shown on input pressure gauge. Remove flowmeter, piezometer, flexible hose, and output pressure gauge.
- (6) Apply leak test solution to hole in relief valve cap. Relief valve shall have re-seated. No leakage of test gas is allowed through relief valve.
- (7) Adjust test regulator to 100 psig / 0.69 MPa (120 psig / 0.83 MPa for 10260-06 and -08 regulators) as shown on input pressure gauge.
- (8) Apply leak test solution (refer to Table 102) to hole in relief valve cap. No leakage of test gas is allowed through relief valve.
- (9) Adjust test regulator to 110 psig / 0.76 MPa (130 psig / 0.89 MPa for 10260-06 and -08 regulators) as shown on input pressure gauge.
- (10) Apply leak test solution to hole in relief valve cap. Relief valve shall show leakage at this pressure.
- (11) Adjust test regulator to 0 psig (0 MPa) as shown on input pressure gauge.
- (12) Dry the regulator assembly with a stream of clean, dry, oil-free air.

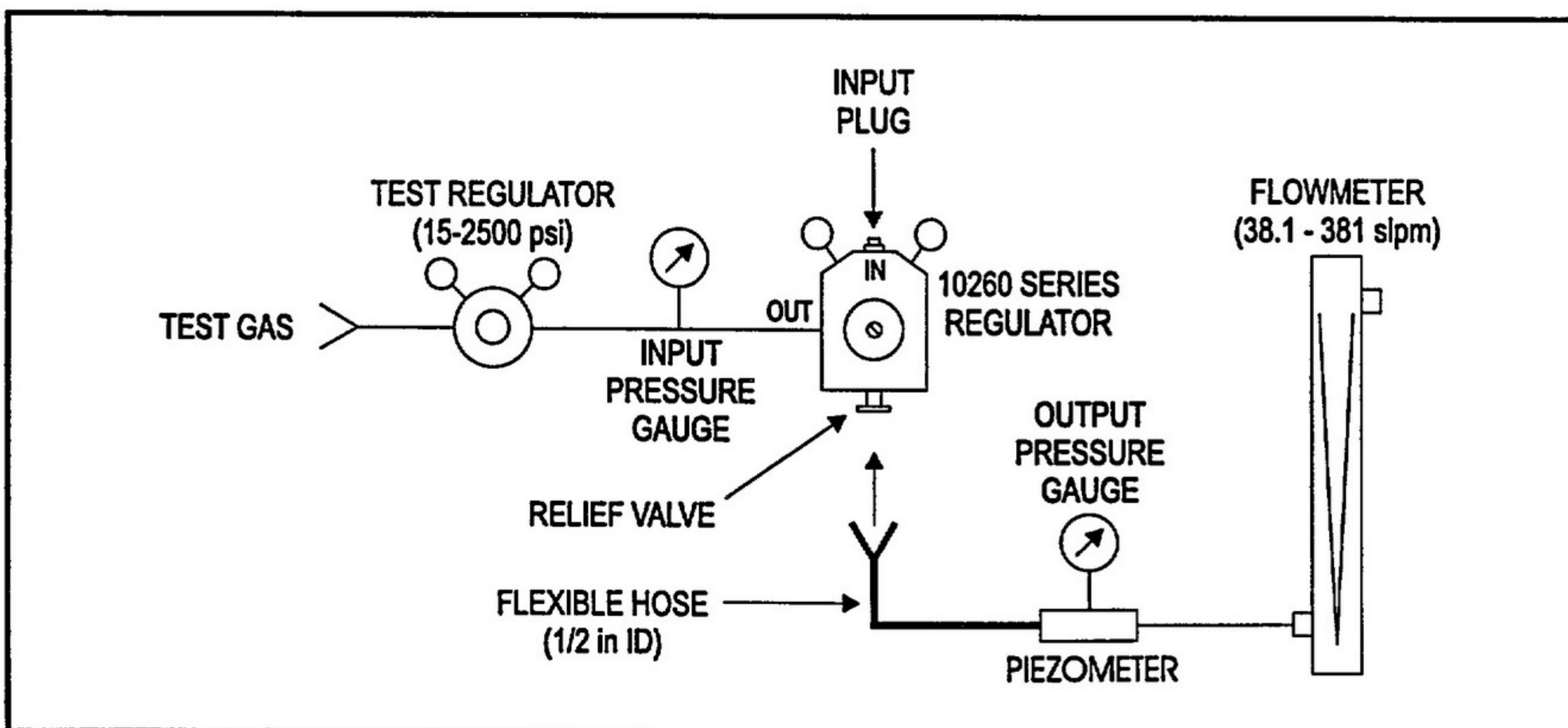


Figure 102: Relief Valve Test Set-up

35-20-57

5. Test Procedures (Continued)

D. Flow Test (See Table 103)

- (1) Attach regulator assembly to the test equipment as shown in Figure 103. Use the flowmeter (0.62 - 6.2 slpm) and set the flow control valve to the closed position (clockwise).
- (2) Adjust test regulator to 150 psig (1.03 MPa) as shown on input pressure gauge. Output pressure as indicated on output pressure gauge, shall be 70-75 psig / 0.48-0.52 MPa (94 psig / 0.65 MPa maximum for 10260-06 and 10260-08).
- (3) Adjust flow control valve to have a flow indication of 2.0 lpm (NTPD) as shown on flowmeter. The regulated output pressure, as indicated on output pressure gauge, shall not be more than 8 psig (0.06 MPa) less than the output pressure indicated in step (2).
- (4) Change the one flowmeter (0.62 - 6.2 slpm) to the other flowmeter (38.1 - 381 slpm) and adjust the flow control valve to obtain flow indications of 100, 200 and 300 lpm (NTPD). Regulated output pressures shall be within the pressures shown in Table 103.
- (5) Set flow control valve to the closed position (clockwise) and adjust test regulator to 1800 psig (12.41 MPa) as shown on input pressure gauge. Output pressure, as indicated on output pressure gauge, shall be 60-75 psig / 0.41-0.52 MPa (94 psig / 0.65 MPa maximum for 10260-06 and 10260-08).
- (6) Adjust flow control valve for flow indications on flowmeter of 100, 200 and 300 lpm (NTPD) as shown in Table 103. Regulated output pressures shall be within the pressures shown in Table 103.
- (7) Decrease test regulator pressure to 0 psig (0 MPa) as shown on the input pressure gauge.

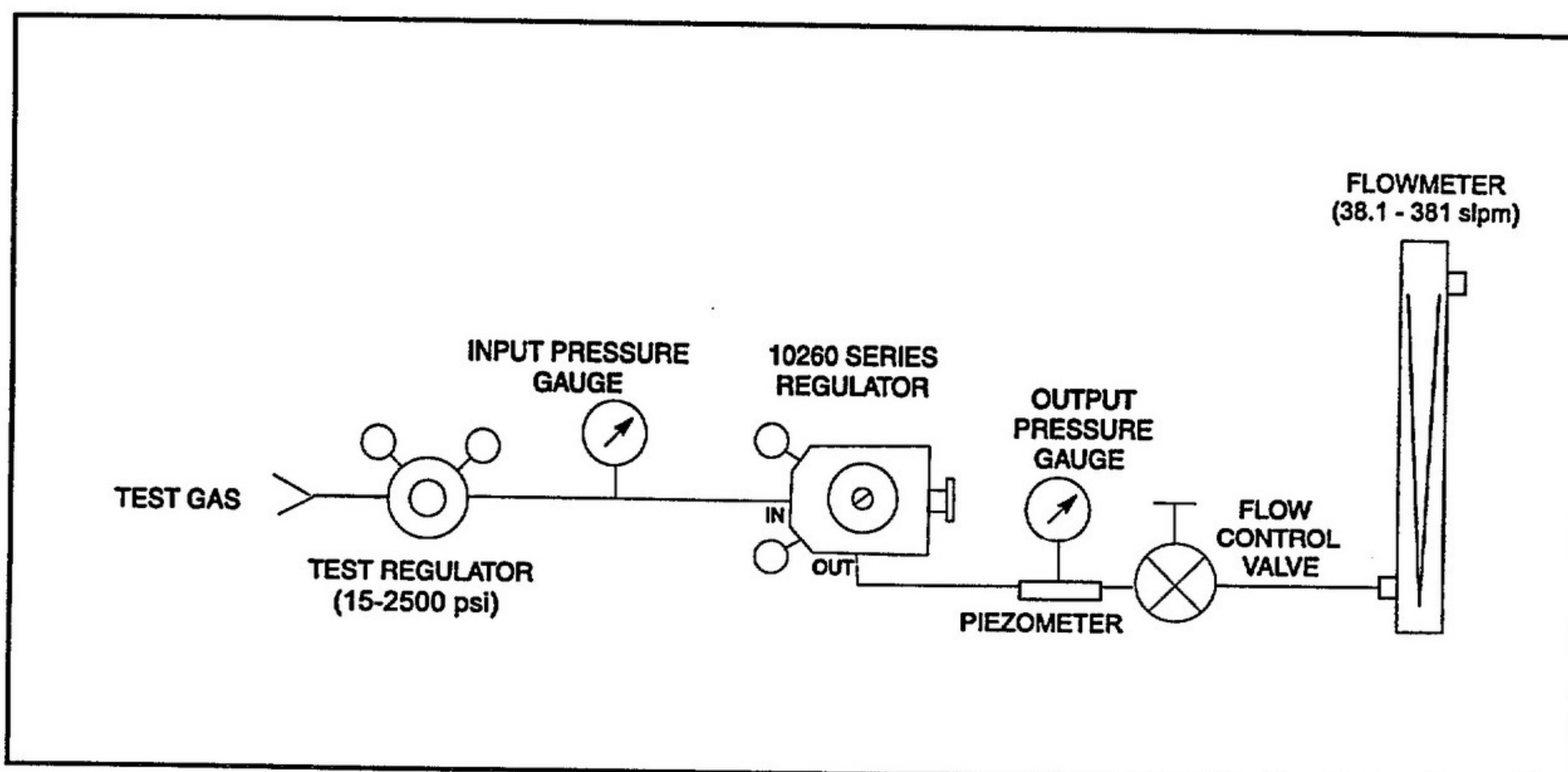


Figure 103: Flow Test Set-up

Table 103: Regulation Check Pressure/Flow Values

REGULATOR UNDER TEST PART No.10260-__	FLOW lpm (NTPD)	INLET PRESSURE	ALLOWABLE REGU- LATED OUTPUT PRESSURE		INLET PRESSURE	ALLOWABLE REGU- LATED OUTPUT PRESSURE	
			(psig)	(MPa)		(psig)	(MPa)
02, 04, 18	0	150 psig (1.03 MPa)	70-75	0.48-0.52	1800 psig (12.41 MPa)	60-75	0.41-0.52
	2		*	*		N/A	N/A
	100		50-75	0.34-0.52		50-75	0.34-0.52
	200		50-75	0.34-0.52		50-75	0.34-0.52
	300		50-75	0.34-0.52		50-75	0.34-0.52
06 and 08	0		94 MAX	0.65 MAX		94 MAX	0.65 MAX
	100		70-94	0.48-0.65		70-94	0.48-0.65
	200		70-94	0.48-0.65		70-94	0.48-0.65
	300		70-94	0.48-0.65		70-94	0.48-0.65

* = Output pressure shall not drop more than 8 psig from the output pressure at 150 psig (input) and 0 lpm output flow.

5. Test Procedures (Continued)

E. Shelf Storage Test

- (1) Refer to the ASSEMBLY section, para. 6, (Storage Instructions) of this manual, and store the 10260 Series Oxygen Regulator Assembly for a minimum of 48 hours.
- (2) Repeat test procedures described in paragraphs 5.C. (Relief Valve Test) and 5.D. (Flow Test).

6. Fault Isolation

See Troubleshooting Chart (Table 104) for fault isolation of the 10260 Series Oxygen Regulator Assemblies.

Table 104: Troubleshooting Chart

TROUBLE	PROBABLE CAUSE	REMEDY
Leakage at plug(s) (50, 90) or gauge (10, 20, 60).	Loose plug or gauge.	Tighten plug or gauge.
	Damaged plug or gauge(s)	Replace plug or gauge.
After adjustment, output pressure slowly increases.	Valve seat (300) dirty, scored or leaking.	Clean or replace valve seat.
	Valve (280) bent or scratched.	Replace valve.
	Seat retainer (290) loose.	Tighten seat retainer.
Output pressure cannot be regulated (output pressure follows inlet pressure).	Damaged diaphragm (250).	Replace diaphragm.
	Links (380) or (410) not operating freely.	Disassemble, clean and re-assemble links.
Unable to adjust regulator for desired output at flow.	Valve (280) not adjusted correctly.	Adjust valve.
Output pressure fluctuates at flow.	Links (380) or (410) not operating freely.	Disassemble linkage assembly, inspect for burrs; clean and re-assemble.
Relief valve (100, 110) leaks.	Damaged relief valve.	Replace relief valve.
Relief valve (100, 110) does not operate within pressure tolerances.	Damaged relief valve.	Replace relief valve.
Pressure on oxygen gauge (60) is not correct.	Damaged oxygen gauge (60).	Replace oxygen gauge (60)

DISASSEMBLY

1. General

This section describes the equipment and procedures necessary for disassembly of the 10260 Series Oxygen Regulator Assemblies. Most repair procedures do not require complete disassembly of the regulator. Disassemble units only to level necessary, as determined in the TESTING AND FAULT ISOLATION section, to access suspect components. Refer to the ILLUSTRATED PARTS LIST section of this manual for the item numbers given in parentheses.

2. Special Tools and Equipment

A list of special tools and/or equipment required for disassembly of the 10260 Series Oxygen Regulator Assemblies is presented in Table 301. Entries in the "ITEM NO." column refer to the tool illustrations presented in Figure 901. Equivalent tools and/or equipment may be used for the listed items.

Table 301: Special Tools and/or Equipment

ITEM NO.	PART NUMBER	PART NAME	APPLICATION
1	10260-T52	Punch	Install/remove pin (340)
2	10260-T52-1	Screwdriver	Install/remove valve (280)
3	10260-T52-2	Screwdriver	Install/remove tube (430)
4	10260-T52-3	Screwdriver	Install/remove retainer (290)
6	10260-T91	Spanner Wrench	Install/remove plate (240)
7	10260-T91-1	Spanner Wrench	Install/remove cap (190)
8	10260-T91-2	Open-end Wrench	Install/remove nut (310)
9	10260-T91-3	Pliers	Compress spring (350) when installing/removing spacer (260)

3. Disassembly

WARNING: ALL PROCEDURES DESCRIBED IN THIS MANUAL SHALL BE PERFORMED IN AN AREA FREE OF DUST, LINT, FINE METAL FILINGS, OIL, GREASE, FLAMMABLE SOLVENTS OR OTHER COMBUSTIBLE MATERIALS. THESE MATERIALS MAY CONTAMINATE THE PRESSURE REGULATOR CAUSING AN EXPLOSION OR FIRE RESULTING IN SERIOUS PERSONAL INJURY OR DEATH.

WARNING: FAILURE TO USE TOOLS THAT ARE FREE FROM DUST, LINT, FINE METAL FILINGS, OIL, GREASE, FLAMMABLE SOLVENTS OR OTHER COMBUSTIBLE MATERIALS ON PARTS THAT ARE EXPOSED TO PRESSURIZED OXYGEN MAY RESULT IN A FIRE OR EXPLOSION CAUSING PERSONAL INJURY OR DEATH

CAUTION: WHEN REMOVING GAUGE (10, 20 OR 60) FROM BODY (480), DO NOT USE GAUGE BODY AS A LEVER. USE A WRENCH ON THE FLATS OF THE SQUARE BOSS ABOVE THE THREADS.

NOTE: Prior to disassembling a 10260 regulator, note the part number and determine the parts applicable to that assembly (refer to "EFFECT CODE" column of the Illustrated Parts List). Disregard any instructions that do not apply to the particular assembly being overhauled.

- A. Unthread gauge (10 or 20), or plug (50) from body (480). Remove bezel-lens (40A) or bezel (-30) and lens (-40) from gauge, as required.
- B. Unthread gauge (60), or plug (90) from body (480). Remove bezel-lens (80A) or bezel (-70) and lens (-80) from gauge, as required.
- C. Remove relief valve (100 or 110) from body (480). DO NOT remove seal (120) or lockwire from relief valve.
- D. Remove seal (140), lockwire and screws (150); remove plate (130).
- E. Remove nut (160) and screw (170).
- F. Un-thread cap (190) using spanner wrench (7, Figure 901). Use care not to damage cap.
- G. Remove guide (200) and spring (210 or 220).
- H. Un-thread nut (230). Using spanner wrench (6, Figure 901) remove plate (240).
- J. Remove diaphragm (250).

3. Disassembly (Continued)

- | K. Remove spacer (260) using pliers (9, Figure 901) to compress spring (350).
- | L. Remove filter (270) from body (480). Back nut (310) away from shaft (420). Remove valve (280) from body (480) using screwdriver (2, Figure 901).
- | M. Using screwdriver (4, Figure 901), unthread retainer (290) from body (480). Remove seat (300).
- | N. Remove nut (310) using wrench (8, Figure 901).
- | P. Remove screws (320) and gaskets (330). Using punch (1, Figure 901) remove pin (340) from body (480). Remove spring (350).
- | Q. Remove rings (360) and push pin (370) through link (380). Remove links (380) and actuator (390).
- | R. Remove rings (360) and push pin (400) through link (410). Remove link (410) and shaft (420).
- | S. Remove tube (430) using screwdriver (3, Figure 901).
- | T. Remove plate (440, -450, -460) from body (480) by removing screws (470).

CLEANING

1. General

This section contains information regarding the equipment and procedures required for cleaning of the 10260 Series Oxygen Regulator Assemblies. Prior to cleaning, units shall be disassembled in accordance with the Disassembly section of this document.

2. Safety

WARNING: SUITABLE EYE PROTECTION SHALL BE WORN DURING CLEANING PROCEDURES TO PREVENT EYE INJURIES.

WHEN USING CLEANING SOLVENTS, AVOID PROLONGED OR REPEATED CONTACT WITH SKIN AND INHALATION OF TOXIC VAPORS.

CLEANING PROCEDURES SHALL ONLY BE PERFORMED IN AN APPROVED CLEANING CABINET, OR IN A WELL VENTILATED ROOM OR AREA.

DO NOT USE SOLVENTS NEAR OPEN FLAMES, OR IN AREAS WHERE HIGH TEMPERATURES PREVAIL.

DO NOT ALLOW OIL, GREASE, FLAMMABLE SOLVENTS, OR OTHER COMBUSTIBLE MATERIALS TO COME IN CONTACT WITH PARTS THAT WILL BE EXPOSED TO PRESSURIZED OXYGEN. DUST, LINT, AND FINE METAL FILINGS, ARE ALSO POTENTIAL COMBUSTIBLES THAT MIGHT IGNITE, AND RESULT IN AN EXPLOSION, WHEN EXPOSED TO PRESSURIZED OXYGEN.

3. Cleaning Materials

A list of cleaning materials is presented in Table 401. Equivalent materials may be substituted.

Table 401: Cleaning Materials

MATERIAL	DESCRIPTION	MANUFACTURER (W/ VENDOR CODE)
Cleaner	Nonionic detergent, Type I (MIL-D-16791)	Commercially Available
Degreasing Agent	Genesolv 2000 or 1, 1-Dichloro-1-fluoroethane	Allied Signal Corp. Morristown, NJ USA (V72658)

4. Cleaning Procedures

Cleaning procedures are divided into two categories: metallic components and non-metallic components. Cleaning procedures for each category are presented below.

A. Metallic Components

Clean metallic components using a vapor degreasing method with degreasing agent specified in Table 401. Dry components with clean, dry (oil-free) air. Hydrocarbon contamination shall not exceed 1.0 mg. per square foot.

B. Non-Metallic Components

Clean non-metallic components using an ultrasonic, non-ionic detergent and water cleaning system. Parts shall be completely rinsed with clear water, and dried using clean, dry (oil-free) air. Hydrocarbon contamination shall not exceed 1.0 mg. per square foot.

CHECK

1. General

Following disassembly and cleaning procedures described in preceding sections of this document, all regulator assembly components shall be checked prior to use in reassembly. If doubt exists about serviceability of a part, replace it. Refer to the ILLUSTRATED PARTS LIST section of this manual for the item numbers given in the parentheses.

NOTE: Do not examine gaskets, diaphragms, seals, packings, o-rings or filters. These items shall be replaced each time they are removed during disassembly.

2. Regulator Components

Check regulator components as indicated below:

A. Visually inspect all surfaces and threaded areas for evidence of damage, contamination, galling, burrs, excessive wear and corrosion.

NOTE: Excessive wear shall be defined as any obvious deformation, or deterioration of a part, which may render the unit inoperative or beyond operational limits.

B. Visually inspect all packing sealing surfaces for scratches or other obvious damage that may impair operation of the regulator assembly.

C. Check for contamination or foreign materials in the pressure ports of gauges (10, 20, 60), regulator body (480), and relief valve (100, 110).

REPAIR

1. General

This section defines the scope of repair procedures that shall be performed with respect to the 10260 Series Oxygen Regulator Assemblies. Prior to repair, components shall have been evaluated in accordance with the Check section of this document.

2. Regulator Components

Regulator repair shall be limited to only those activities below:

- A. Cleaning
- B. Burr removal
- C. Thread chasing
- D. Replacement of cracked, bent, broken, scored, or otherwise defective components
- E. Replacement of any gasket, diaphragm, seal, packing, o-ring or filter, when removed during disassembly.

ASSEMBLY

1. General

This section describes the equipment and procedures necessary for assembly of the 10260 Series Oxygen Regulator Assemblies. Refer to the ILLUSTRATED PARTS LIST section of this manual for item numbers given in parentheses.

2. Special Tools and Equipment

A list of special tools and/or equipment required for assembly of the 10260 Series Oxygen Regulator Assemblies is presented in Table 701. Entries in the "ITEM NO." column refer to the tool illustrations presented in Figure 901. Equivalent Tools and/or Equipment may be used for the listed items.

WARNING: ALL PROCEDURES DESCRIBED IN THIS MANUAL SHALL BE PERFORMED IN AN AREA FREE OF DUST, LINT, FINE METAL FILINGS, OIL, GREASE, FLAMMABLE SOLVENTS OR OTHER COMBUSTIBLE MATERIALS. THESE MATERIALS MAY CONTAMINATE THE PRESSURE REGULATOR CAUSING AN EXPLOSION OR FIRE RESULTING IN SERIOUS PERSONAL INJURY OR DEATH.

WARNING: FAILURE TO USE TOOLS THAT ARE FREE FROM DUST, LINT, FINE METAL FILINGS, OIL, GREASE, FLAMMABLE SOLVENTS OR OTHER COMBUSTIBLE MATERIALS ON PARTS THAT ARE EXPOSED TO PRESSURIZED OXYGEN MAY RESULT IN A FIRE OR EXPLOSION CAUSING PERSONAL INJURY OR DEATH

Table 701: Special Tools and/or Equipment

ITEM NO.	PART NUMBER	PART NAME	APPLICATION
1	10260-T52	Punch	Install/remove pin (340)
2	10260-T52-1	Screwdriver	Install/remove valve (280)
3	10260-T52-2	Screwdriver	Install/remove tube (430)
4	10260-T52-3	Screwdriver	Install/remove retainer (290)
6	10260-T91	Spanner Wrench	Install/remove plate (240)
7	10260-T91-1	Spanner Wrench	Install/remove cap (190)
8	10260-T91-2	Open-end Wrench	Install/remove nut (310)
9	10260-T91-3	Pliers	Compress spring (350) when installing/removing spacer (260)

Note: All tools and equipment listed above are manufactured by Scott Aviation, Lancaster, NY. (V53655)

3. Assembly Materials

A list of consumable materials, required for assembly of the 10260 Series Oxygen Regulator Assemblies, is provided in Table 702. Equivalent materials may be used for the listed items except for oxygen lubricant.

Table 702: Consumable Assembly Materials

MATERIAL	DESCRIPTION	MANUFACTURER (with Vendor Code)
Sealing Tape	PTFE Ribbon Dope CID A-A-58092, Size 1 (SPN 50011-00)	Commercially Available
Oxygen Lubricant	Krytox 240 AC (SPN 50527-00)	E.I. DuPont DeNemours & Co., Inc. Wilmington, DE 19899 USA (V18873)
Lockwire	MS20995C20 (SPN 13603-00)	Commercially Available

4. Pre-Assembly Requirements

- A. All components, that are to be used in assembly of the 10260 Series Oxygen Regulator Assemblies, shall have been cleaned and checked in accordance with preceding sections of this document.
- B. Unless otherwise noted, all packings, seals and o-rings shall be lubricated with a thin film of Krytox 240 AC Lubricant, prior to installation.

5. Assembly Procedures

NOTE: Not all assembly procedures are required for each valve configuration. Refer to the "EFF CODE" column of the ILLUSTRATED PARTS LIST section of the manual to determine the components used on the valve configuration being assembled.

A. Wrap 1-1/2 turns of thread sealing tape to relief valve (100 or 110), gauge (10, 20 or 60), or plug (50 or 90). Wrap thread sealing tape in the direction of the thread spiral, beginning with the first thread. In no case shall the tape extend beyond the first thread. Trim off excess tape.

NOTE: Tape shall be applied in accordance with MIL-T-27730.

B. Attach plate (440, -450, -460) to body (480) with screws (470).

C. Thread tube (430) into body (480) using screwdriver (3, Figure 901). Tighten the tube until it bottoms in the body.

D. Assemble shaft (420) to link (380) with pin (370). Lock pin in place with retaining rings (360).

E. Slide actuator (390) through shaft (420); using pin (400), connect link (380), link (410) and actuator (390). Lock pin in place with retaining rings (360). Place spring (350) on shaft (420). Place this assembly into body (480).

F. Push pin (340) through body (480) and rear pivot of link (410) using punch (1, Figure 901). Install gaskets (330) and screws (320). Torque screws to 40-50 IN LBS (4.5 - 5.7 Nm).

G. Place seat (300) on valve (280). Thread nut (310) onto valve (280). Place this assembly in body (480). Using screwdriver (2, Figure 901) thread valve (280) into shaft (420) until flats of nut (310) are exposed beyond wall of body (480). Hold nut (310) with wrench (8, Figure 901) and back-off valve (280) 1-1/2 turns counterclockwise. Lock nut (310) in place using wrench (8, Figure 901).

NOTE: Refer to enlarged view of items 2 and 3 (Figure 3, Description & Operation section of this manual) for proper installation of seat (300) on valve (280).

H. Compress spring (350) and install spacer (260) into place using pliers (9, Figure 901). Check that spacer is secure and maintains the spring in a compressed position.

NOTE: Manually depress actuator (390) and note movement of shaft (420) toward the inlet opening. The linkage parts must move freely without binding or excessive play. Retest for free movement of the linkage.

5. Assembly Procedures (Continued)

J. Thread retainer (290) into body (480) and tighten using screwdriver (4, Figure 901) in outer slots of thread retainer; torque thread retainer to 35-40 IN LBS (4.0 - 4.5 Nm).

K. Apply a wipe coat of oxygen lubricant only to the outer ring of diaphragm (250). Install diaphragm (250) then plate (240) on actuator (390), finger tight only. Using spanner wrench (6, Figure 901) to hold plate, turn nut (230) to secure plate in position. Torque nut to 35 IN LBS (4.0 Nm).

L. Place spring (210 or 220) and guide (200) on plate (240). Using spanner wrench (7, Figure 901), screw cap (190) into body (480) until cap is threaded all the way into the body.

M. Install screw (170) through cap (190) and against guide (200). The screw must seat in the indentation on the guide. A sufficient amount of the screw must remain exposed to maintain a minimum of 1-1/2 threads engagement in nut (160) after proper regulator setting has been established.

NOTE: DO NOT install nut (160) at this time.

N. Install relief valve (100 or 110) into body (480). Torque relief valve to 40-50 IN LBS (4.5-5.7 Nm).

P. Install plug (90) into body (480). Torque plug to 30-40 IN LBS (3.4-4.5 Nm).

CAUTION: WHEN ASSEMBLING GAUGE (60) TO BODY, DO NOT USE GAUGE BODY AS A LEVER. USE A WRENCH ON THE FLATS OF THE SQUARE BOSS ABOVE THE THREADS.

Q. Thread bezel-lens (80A) onto gauge or place lens (-80) on gauge (60), then thread bezel (-70) over lens onto gauge. Install gauge (60) in body (480); torque gauge to 30-40 IN LBS (3.4-4.5 Nm).

NOTE: The single piece bezel-lens (80A) is used on gauges (60) with three evenly spaced, partial thread dimples on the case. The older separate bezel (-70) and lens (-80) are used on gauges with continuous threads on the case (20 threads per inch).

R. Install plug (50) into body (480). Torque plug to 30-40 IN LBS (3.4-4.5 Nm).

CAUTION: WHEN ASSEMBLING GAUGE (10 OR 20) TO BODY, DO NOT USE GAUGE BODY AS A LEVER. USE A WRENCH ON THE FLATS OF THE SQUARE BOSS ABOVE THE THREADS.

5. Assembly Procedures (Continued)

S. Thread bezel-lens (40A) onto gauge or place lens (-40) on gauge (10 or 20), then thread bezel (-30) over lens onto gauge. Install gauge (10 or 20) in body (480); torque gauge to 30-40 IN LBS (3.4-4.5 Nm).

NOTE: The single piece bezel-lens (40A) is used on gauges (10 or 20) with three evenly spaced, partial thread dimples on the case. The older separate bezel (-30) and lens (-40) are used on gauges with continuous threads on the case (20 threads per inch).

T. Test the partially assembled regulator in accordance with paragraphs 5.A thru 5.E of the Testing and Fault Isolation Section of this document.

U. Thread nut (160) on screw (170). Secure plate (130) to nut (160) using screws (150). Secure screws (150), nut (160) and cap (190) to body (480) using lockwire. Install lockwire per MS 33540; secure lockwire with seal (140).

V. Install filter (270) by pressing filter into body (480).

6. Storage Instructions

A. Seal all ports to prevent foreign matter from entering the regulator assembly. Store in sealed polyethylene or polyvinyl bag.

B. DO NOT use preservative coating on the regulator assembly.

FITS AND CLEARANCES

Torque values, critical to the assembly and operation of the 10260 Series Oxygen Regulator Assemblies, are listed in Table 801.

Table 801: Torque Values

IPL REFERENCE (Figure 1) ITEM No.	NOMENCLATURE	TORQUE VALUES	
		U.S. (IN LBS)	METRIC (Nm)
10, 20 or 60	Gauge	30 - 40	3.4 - 4.5
50 or 90	Plug	30 - 40	3.4 - 4.5
100 or 110	Relief Valve	40 - 50	4.5 - 5.7
230	Nut	35	4.0
290	Seat Retainer	35 - 40	4.0 - 4.5
320	Screw	40 - 50	4.5 - 5.7

SPECIAL TOOLS, FIXTURES AND TEST EQUIPMENT

Special tools required for maintenance of the 10260 Series Oxygen Regulator Assemblies are presented in Table 901. Figure 901 illustrates the special tools listed in Tables 901. Test Equipment required for testing of the 10260 Series Oxygen Regulator Assemblies are presented in Table 902. Equivalent tools and/or test equipment may be used for the listed items. Refer to the ILLUSTRATED PARTS LIST section of this manual for the item numbers given in the parentheses.

Table 901: Special Tools

ITEM NO.	PART NUMBER	PART NAME	APPLICATION
1	10260-T52	Punch	Install/remove in (430)
2	10260-T52-1	Screwdriver	Install/remove valve (280)
3	10260-T52-2	Screwdriver	Install/remove tube (340)
4	10260-T52-3	Screwdriver	Install/remove retainer (290)
5	10260-T58-1	Piezometer	Test 10260 Series Reg. Assembly
6	10260-T91	Spanner Wrench	Install/remove plate (240)
7	10260-T91-1	Spanner Wrench	Install/remove cap (190)
8	10260-T91-2	Open-end Wrench	Install/remove nut (310)
9	10260-T91-3	Pliers	Compress spring (350) when installing/removing spacer (260)

Note: All tools and equipment listed above are manufactured by Scott Aviation, Lancaster, NY. (V53655)

Table 902: Test Equipment

NOMENCLATURE	PART NO.	MANUFACTURER (with Vendor Code)
Flexible Hose (1/2 inch [1.27 cm] ID, 1-1/8 inch [2.86] OD, TYGON* Tubing)	AAC00038	Norton Company Worcester, MA 01615-0008 USA (V44197)
Valve, Flow Control	B18VF8	Whitey Company Highland Heights, OH 44143-1533 USA (V12623)
Flowmeter: (0.62 - 6.2 lpm) (38.1 - 381 lpm)	1110CC71DBGAA 1110CK42CBGAA	Emerson Electric Co. Brooks Instrument Div. Hatfield, PA 19440-3052 USA (V91556)
Gauge, Input Pressure (0-2000 psi)	1403 Series	Ametek U.S. Gauge Div. Sellersville, PA 18960-2625 USA (V61349)
Gauge, Output Pressure (0-200 psi)	1403 Series	
Input Plug (Brass, 1/4 inch ANPT pipe plug)	-----	Commercially Available
Regulator, Test (15 - 2500 psi)	26-1014-26	Tescom Corp. Elk River, MN 55330-2445 USA (V5H642)
Piezometer	10260-T58-1	Scott Aviation Lancaster, NY 14086-9502 USA (V53655)
*TYGON is a registered trademark of the Norton Company, Worcester, MA.		

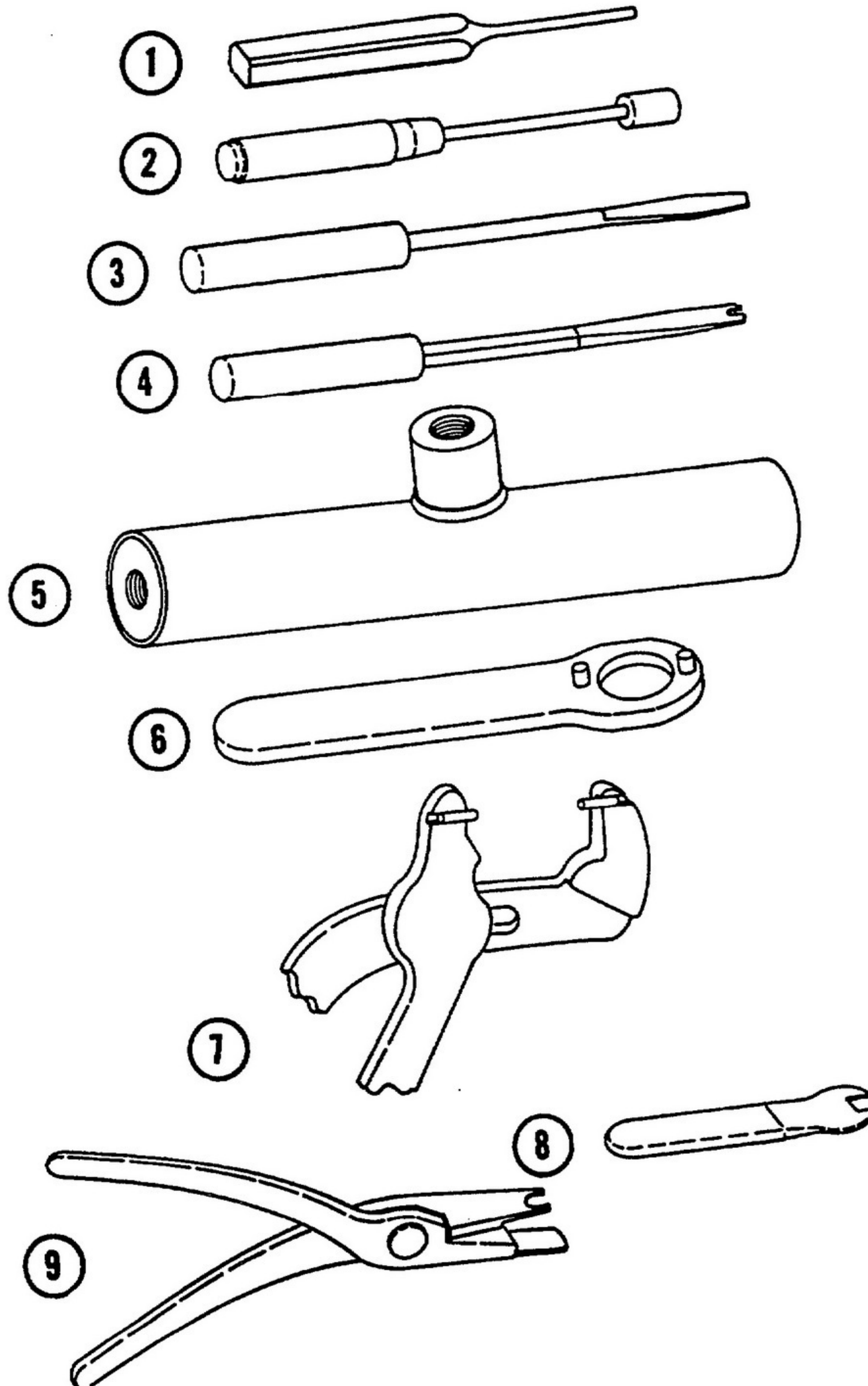


Figure 901: Special Tools

ILLUSTRATED PARTS LIST

1. Introduction

This Illustrated Parts List lists and describes the parts for the 10260 Series Oxygen Regulator Assemblies.

- A. The Illustrated Parts List consists of parts listings and completely indexed drawings. The particular oxygen regulator assemblies are followed immediately by their component parts, properly indented thereunder, to show their relationship to the assembly.
- B. The quantities listed in the "UNITS PER ASSY" column are, in the case of assemblies, the total quantity used per cylinder assembly at the location indicated, while the component parts indented under the assemblies are the quantity used per assembly. The quantities specified, therefore, are not necessarily the total used per cylinder assembly.
- C. The part numbers listed in the "PART NUMBER" column are Scott Aviation part numbers except standard parts, which are listed by "MS" and "AN" part numbers, and vendor items, which are listed by vendor part numbers.
- D. A six place code, following the description of a part, indicates the manufacturer of that part. Standard parts and parts carried under Scott part numbers have no vendor's code. The following list contains the codes, and names and addresses of manufacturers supplying items or articles for the oxygen regulator assemblies. This listing includes the vendor codes presented in the parts lists contained in this section.

VENDOR CODES

<u>CODE</u>	<u>NAME AND ADDRESS</u>
V53655	Scott Aviation Lancaster, NY 14086-9502 USA
V56878	SPS Industries, Unbrako Div. Jenkintown, PA 19046 USA
V61349	US Gauge Ametek, Inc.; US Gauge Div. Sellersville, PA 18960-2625 USA

VENDOR CODES

	<u>CODE</u>	<u>NAME AND ADDRESS</u>
I	V76665	National Lock Washer Div. Charter Wire Co. Sommerville, NJ USA
I		

2. How to use this Illustrated Parts List

- A. If neither the part number nor the nomenclature is known, the part can be found by comparison with the exploded view illustration. When located on the illustration, the index number will refer to the line in the Illustrated Parts List with the part number and the nomenclature.

3. How to determine the applicable "EFFECT CODE"

- A. Parts used on only one part number oxygen regulator assembly (see IPL Figure 1) are indicated by a letter symbol immediately following the description of a part in the "EFFECT CODE" column. An explanation of the letter symbols used is outlined below in Table 1001. A blank "EFFECT CODE" column following a part number indicates that the list part is common to all regulator assemblies.

Table 1001: Effectivity Codes

<u>Part Number</u>	<u>"EFFECT CODE"</u>
10260-02*	A
10260-04*	B
10260-06	D
10260-08	E
10260-18	C

* = Items with the single digit dash numbers (e.g., 10260-2, 10260-4) are identical to items with the two digit dash numbers (e.g., 10260-02, 10260-04, respectively).

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NO.	NOMENCLATURE 1234567	EFF. CODE	UNITS PER ASSY
1 - 1	10260-02*		OXYGEN REGULATOR ASSEMBLY	A	RF
-1A	10260-04*		OXYGEN REGULATOR ASSEMBLY	B	RF
-1B	10260-18		OXYGEN REGULATOR ASSEMBLY	C	RF
-1C	10260-06		OXYGEN REGULATOR ASSEMBLY	D	RF
-1D	10260-08		OXYGEN REGULATOR ASSEMBLY	E	RF
10	10336-00		• GAUGE, OXYGEN	A, B	1
20	10336-01		• GAUGE, OXYGEN	D	1
-30	AR149F		•• BEZEL (V61349)(AR-149-F) (SPN 56750-00) (FOR THREADED CASES ONLY)	A, B, D	1
-40	AG92C		•• LENS (V61349)(AG-92-C)(SPN 13753-00) (FOR THREADED CASES ONLY)	A, B, D	1
40A	BG189		•• BEZEL-LENS (V64528)(BG-189) (SPN 56750-01) (FOR DIMPLED CASES ONLY)	A, B, D	1
50	6818-03		• PLUG	C, E	1
60	802821-11		• GAUGE, OXYGEN	A	1
-70	AR149F		•• BEZEL (V61349)(AR-149-F) (SPN 56750-00) (FOR THREADED CASES ONLY)	A	1
-80	AG92C		•• LENS (V61349)(AG-92-C)(SPN 13753-00) (FOR THREADED CASES ONLY)	A	1
80A	BG189		•• BEZEL-LENS (V64528)(BG-189) (SPN 56750-01) (FOR DIMPLED CASES ONLY)	A	1
90	6818-03		• PLUG	B, C, D, E	1
100	5081-07		• VALVE, RELIEF	A, B, C	1
110	5081-09		• VALVE, RELIEF ATTACHING PARTS	D, E	1
120	2808-00		• SEAL, LOCKWIRE ***		1
130	5056-00		• PLATE, NAME ATTACHING PARTS		1
140	2808-00		• SEAL, LOCKWIRE		1
150	MS35265-2		• SCREW ***		2
160	10333-00		• NUT, LOCK		1
170	58923-00		• SCREW, SET		1
180	59278-00		DELETED		
190	10289-00		• CAP, REGULATOR		1
200	10340-00		• GUIDE, SPRING		1

- ITEM NOT ILLUSTRATED

FIG. ITEM	PART NUMBER	AIRLINE STOCK NO.	NOMENCLATURE 1234567	EFF. CODE	UNITS PER ASSY
1-					
210	10272-00		• SPRING, REGULATING	A, B, C	1
220	27527-01		• SPRING, REGULATING	D, E	1
230	AN315-3		• NUT (SPN 33468-003)		1
240	10341-00		• PLATE, DIAPHRAGM		1
250	800658-00		• DIAPHRAGM (SUPERSEDES 10343-00 DIAPHRAGM AND 10344 SLIP RING)		1
260	10342-00		• SPACER		1
270	10398-00		• FILTER, INLET		1
280	10266-00		• VALVE		1
290	10268-00		• RETAINER, SEAT		1
300	10267-03		• SEAT, VALVE		1
310	10265-00		• NUT, ADJUSTING		1
320	38030N3F4B		• SCREW, SELF-LOCKING (V56878) (SPN 18531-00)		2
330	10286-00		• GASKET, PIVOT PIN		2
340	10287-00		• PIN, PIVOT		1
350	10399-00		• SPRING, MARGINAL		1
360	XRC309		• RING, RETAINING (V76665)(XRC-309) (SPN 13522-00)		4
370	10348-00		• PIN, TOGGLE		1
380	10349-00		• LINK, TOGGLE-FWD		1
390	10345-00		• ACTUATOR, LINK		1
400	10348-01		• PIN, TOGGLE		1
410	10349-01		• LINK, TOGGLE-REAR		1
420	10346-00		• SHAFT, ACTUATOR		1
430	10282-00		• TUBE, VENTURI		1
440	10332-01		• PLATE, IDENT	B	1
-450	10332-03		• PLATE, IDENT	C, D, E	1
-460	10332-05		• PLATE, IDENT ATTACHING PARTS	A	1
470	MS21318-7		• SCREW, DRIVE (SPN 33343-007) ***		2
480	10263-00		• BODY, REGULATOR		1
* = Items with the single digit dash numbers (e.g., 10260-2, 10260-4) are identical to items with the two digit dash numbers (e.g., 10260-02, 10260-04, respectively).					

- ITEM NOT ILLUSTRATED

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 Page 1006
 Sep 9/97